

Work Order ID 61706

Tuesday, August 31, 2010 1:46:03 PM



Page 1

Item ID: D3535-25

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 8/31/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Handwritten signature

Date: 10-8-31

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3535	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Debur if necessary

304.040

B10-9-15

(10)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-9-15

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

S 10/9/15

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval. QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61706

Tuesday, August 31, 2010 1:46:03 PM



Page 2

Item ID:	D3535-25	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Wearshoe					
Start Date:	8/31/2010	Start Qty:	10.00		Cust Item ID:	
Required Date:	9/7/2010	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	NC BRAKE	0.00				<u>10</u>			
Brake NC	Memo	0.00							
Brake NC	1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261 and DT8326 2-Form joggle on Punch as per Dwg D3535 using Jig DT8158 Identify as D3535-25								
				SB 10/09/16					
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00				<u>40</u>			
Quality Control									
				BR 10-9-20					
150 	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00				<u>10</u>			
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 11:45 FINISH TIME: 12:15								

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Page 3

Item ID: D3535-25

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 8/31/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

=) MD 10/09/20

0.00

10

d/

170



Packaging

Packaging

Identify as per dwg & Stock Location

Memo

0.00

FP-18 BR 10-9-20

0.00

(10)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

10/09/21
MF
10-9-20

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Picklist Print

Tuesday, August 31, 2010 1:46:35 PM

Page 1

Work Order ID: 61706



Parent Item: D3535-25



Parent Item Name: Wearshoe


Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA  304/316 .040 Sheet		Purchased	No			100	sf	111.7987	0.51	5.368421			



1810-9-15

Location

Loc Qty

Loc Code

MAT

16.1522

114574

16.1522

114574

10

MAT20

95.6465

112885

2.7475

113062

0.699

115440

92.2

~~114574~~

~~114574~~

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NOTE: Date & initial all entries

Dart Aerospace Ltd

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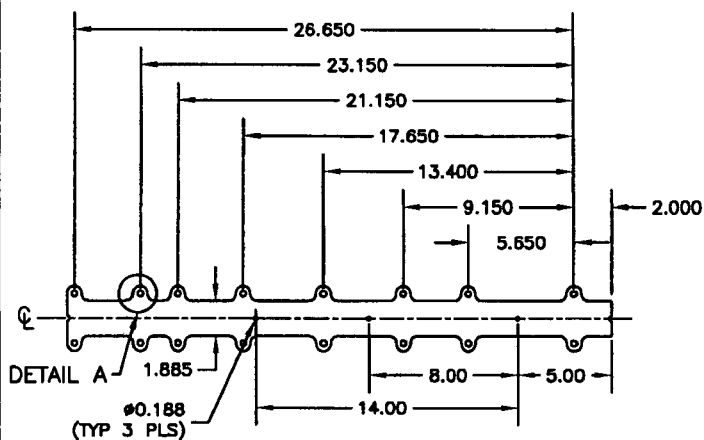
NOTE: Date & initial all entries

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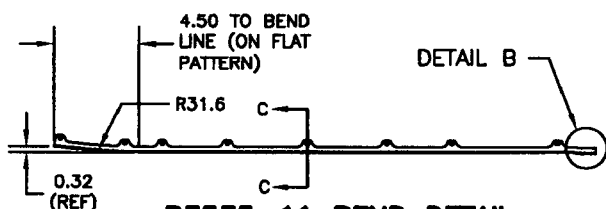
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07.04.24

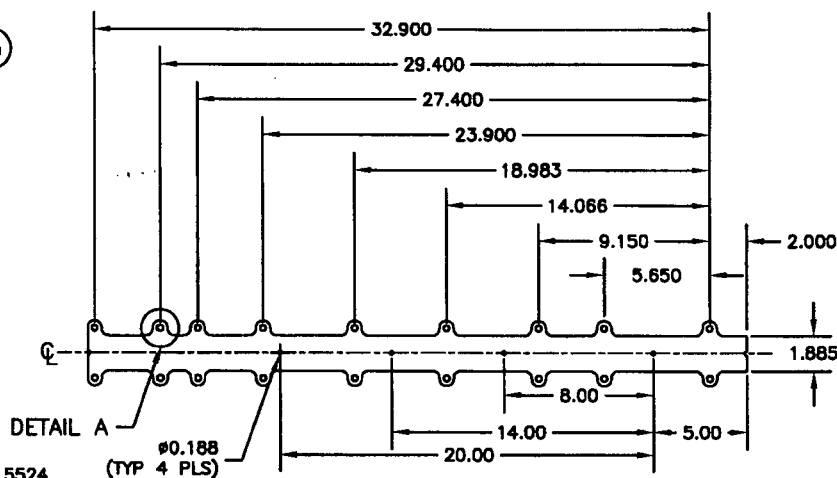
SHOP COI
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *61706*
Rev 10-8-31



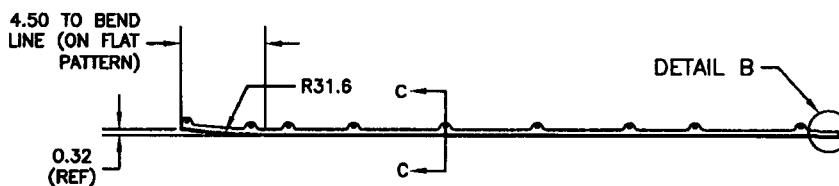
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	TITLE	DATE	CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 7	REV. B
CB	PH	WEARSHOE	07.04.17			D3535		
A	06.10.25	NEW ISSUE						
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC						

W/O:		WORK ORDER CHANGES					
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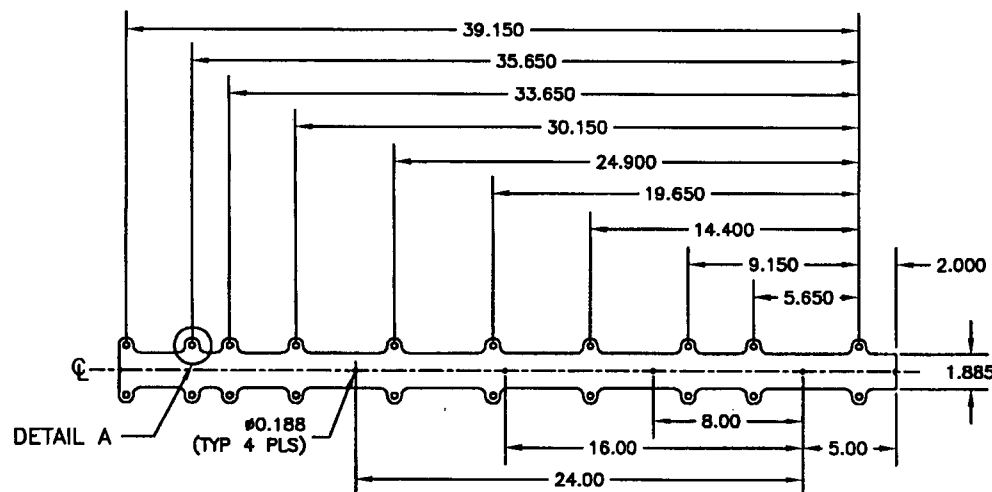
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DART

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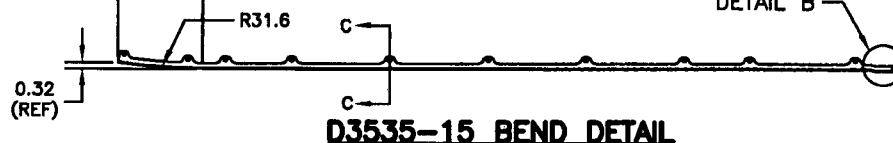
07.04.17

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CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3535	SHEET 2 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:1	

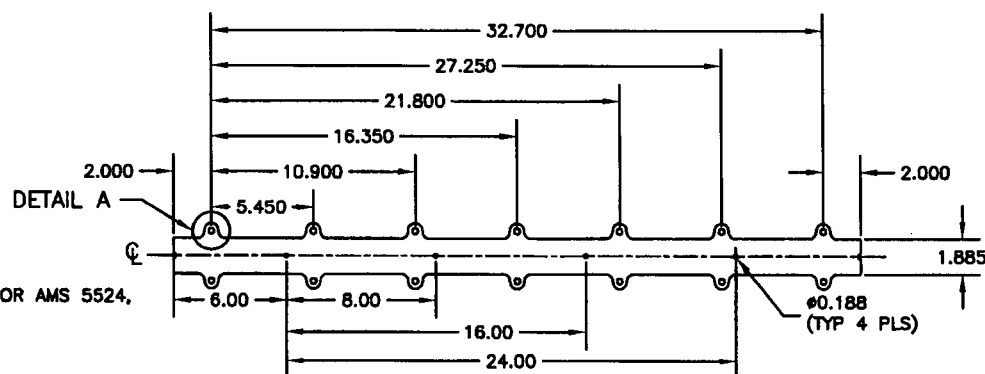


4.50 TO BEND
LINE (ON FLAT
PATTERN)

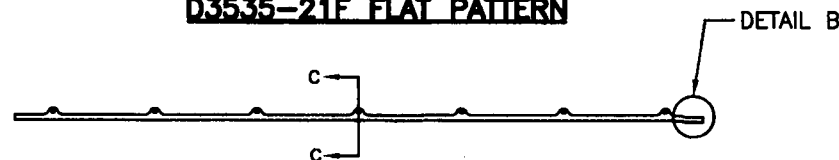
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

NOTES

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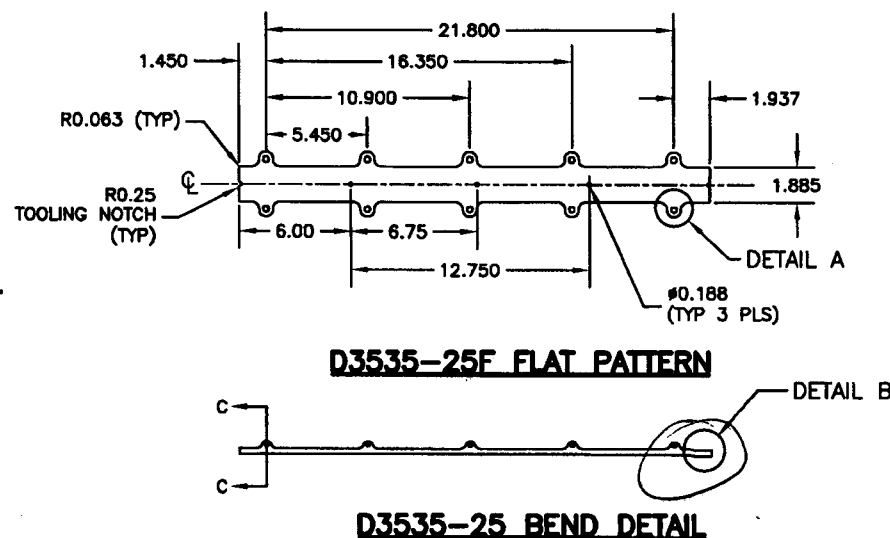
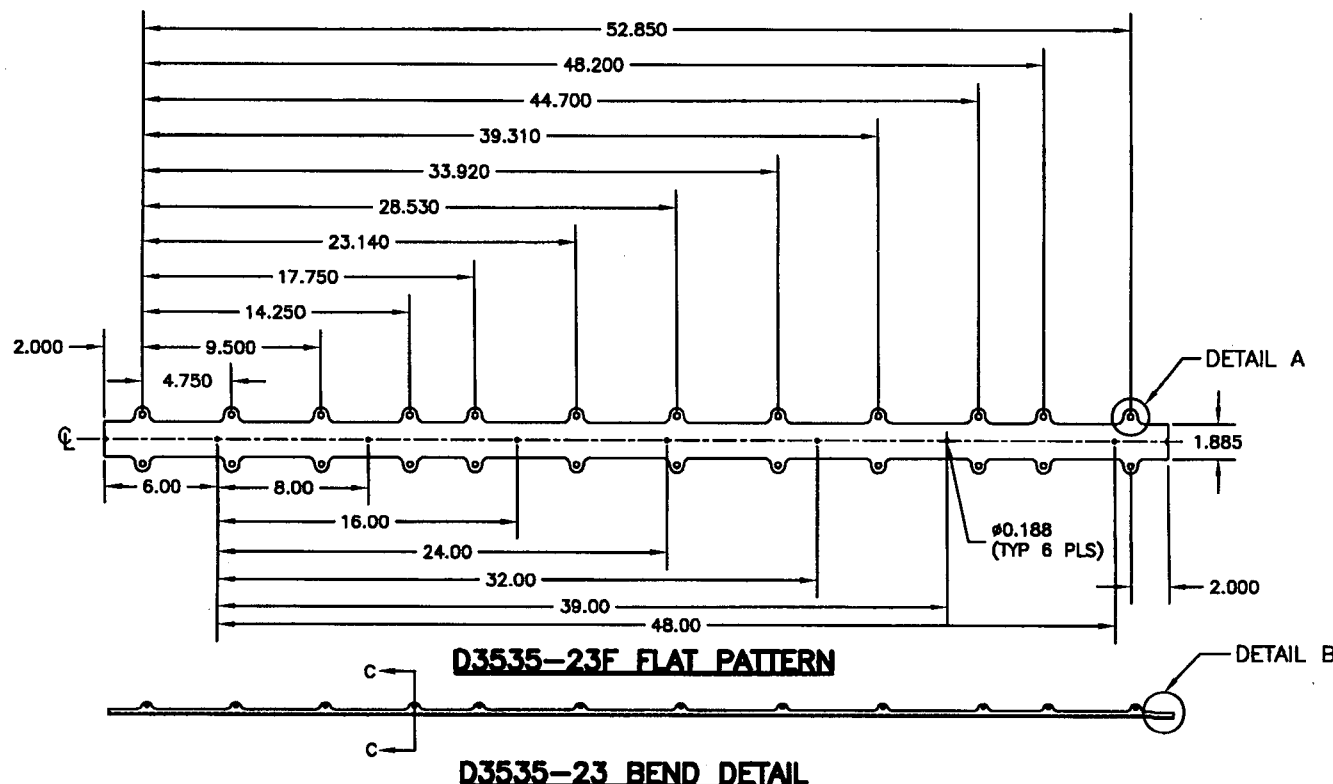
NOTE: Date & initial all entries

DART

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07.04.24

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CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	WEARSHOE
				REV. B
				SHEET 3 OF 7
				SCALE 1:10



NOTES

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w/06704

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

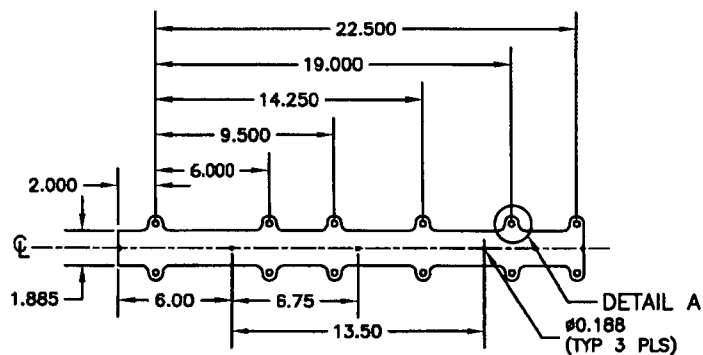
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DART

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07.04.24

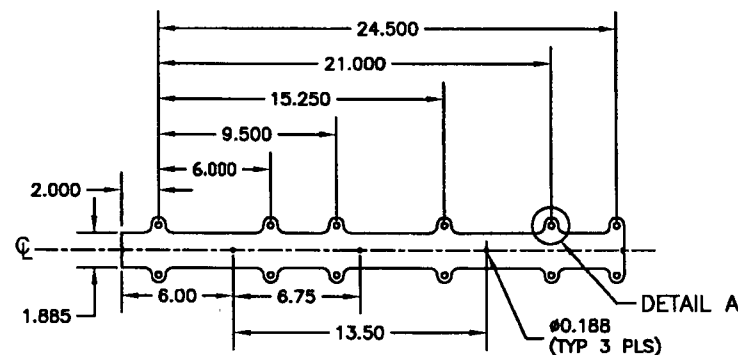


D3535-31F FLAT PATTERN



D3535-31 BEND DETAIL

w/o 61704



D3535-33F FLAT PATTERN



D3535-33 BEND DETAIL

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DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3535	SHEET 4 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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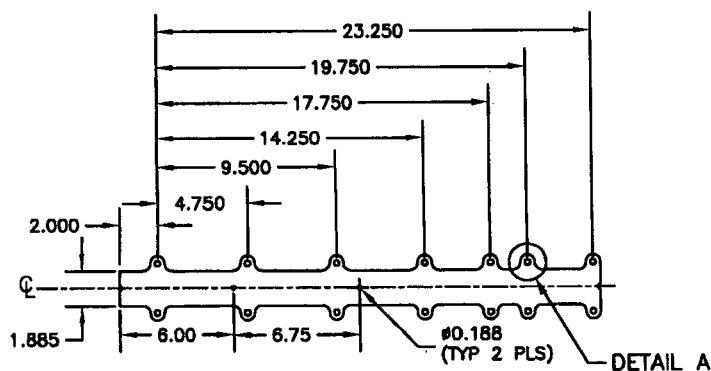
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07.04.24

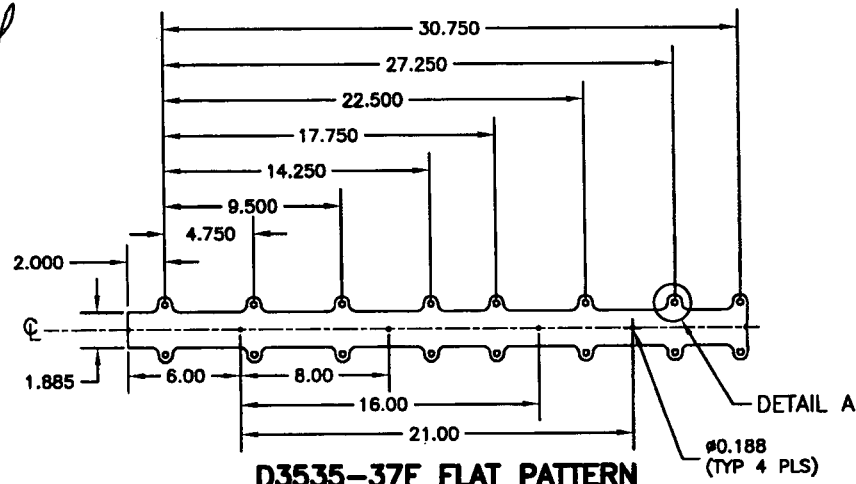


D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL

w/061706



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 5 OF 7
		D3535	
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	

Dart Aerospace Ltd

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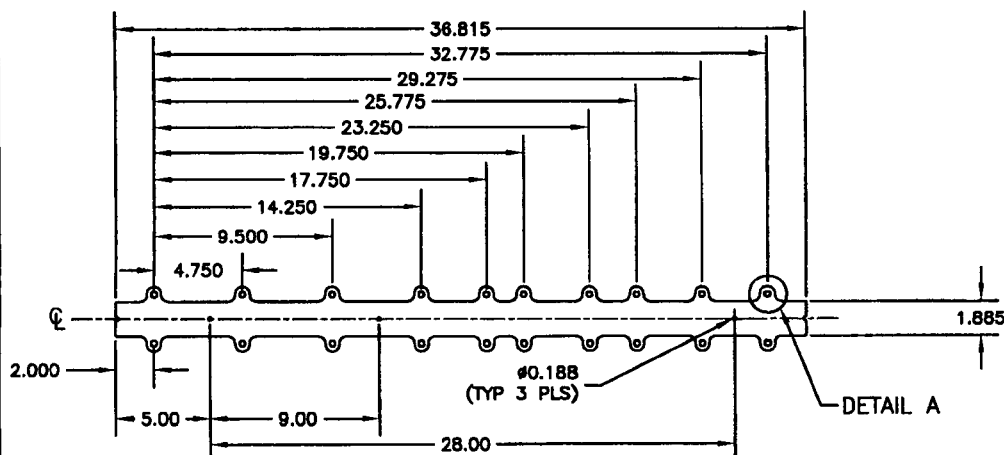
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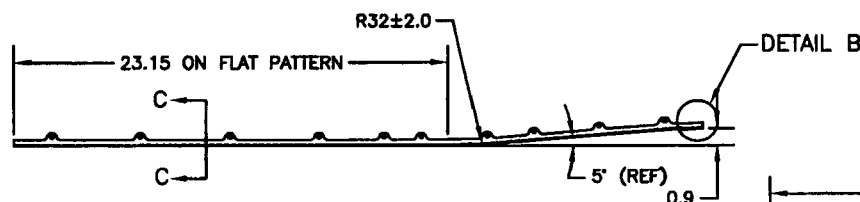
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07.04.17

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CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 6 OF 7
DATE	07.04.17	D3535	SCALE
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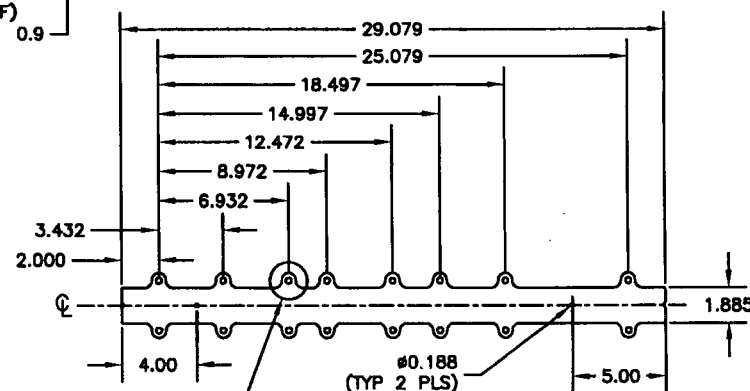


D3535-39F FLAT PATTERN

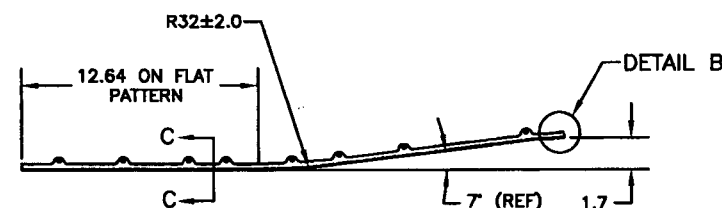


D3535-39 BEND DETAIL

w/o 61704



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

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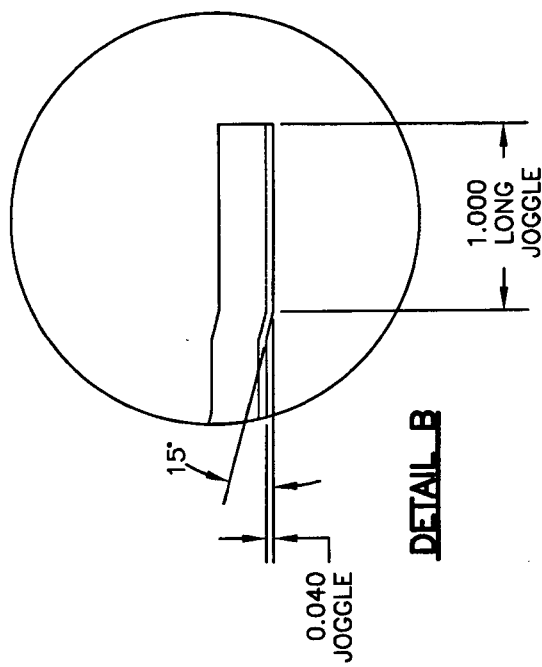
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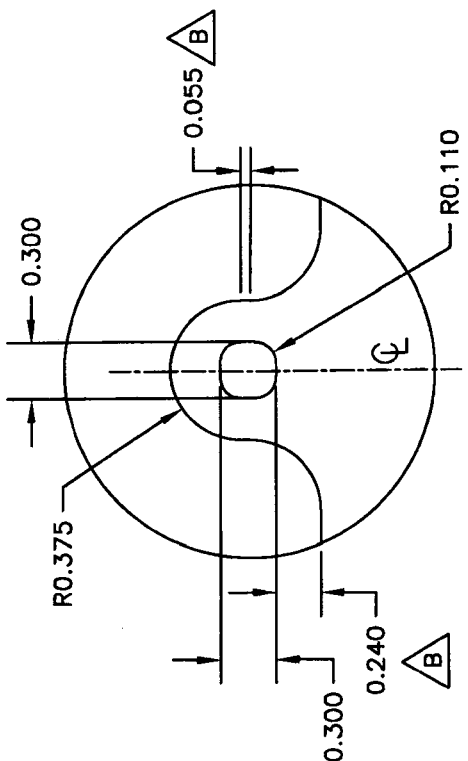


DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17		TITLE WEARSHOE	SCALE 1:1

RELEASED
07.04.24 *[Signature]*

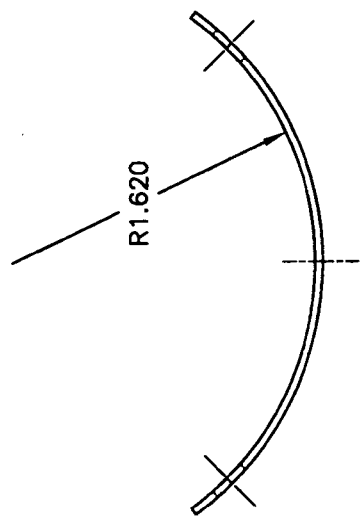


DETAIL B



DETAIL A

w/0 6/7/04



SECTION C-C

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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